

FIG. 1

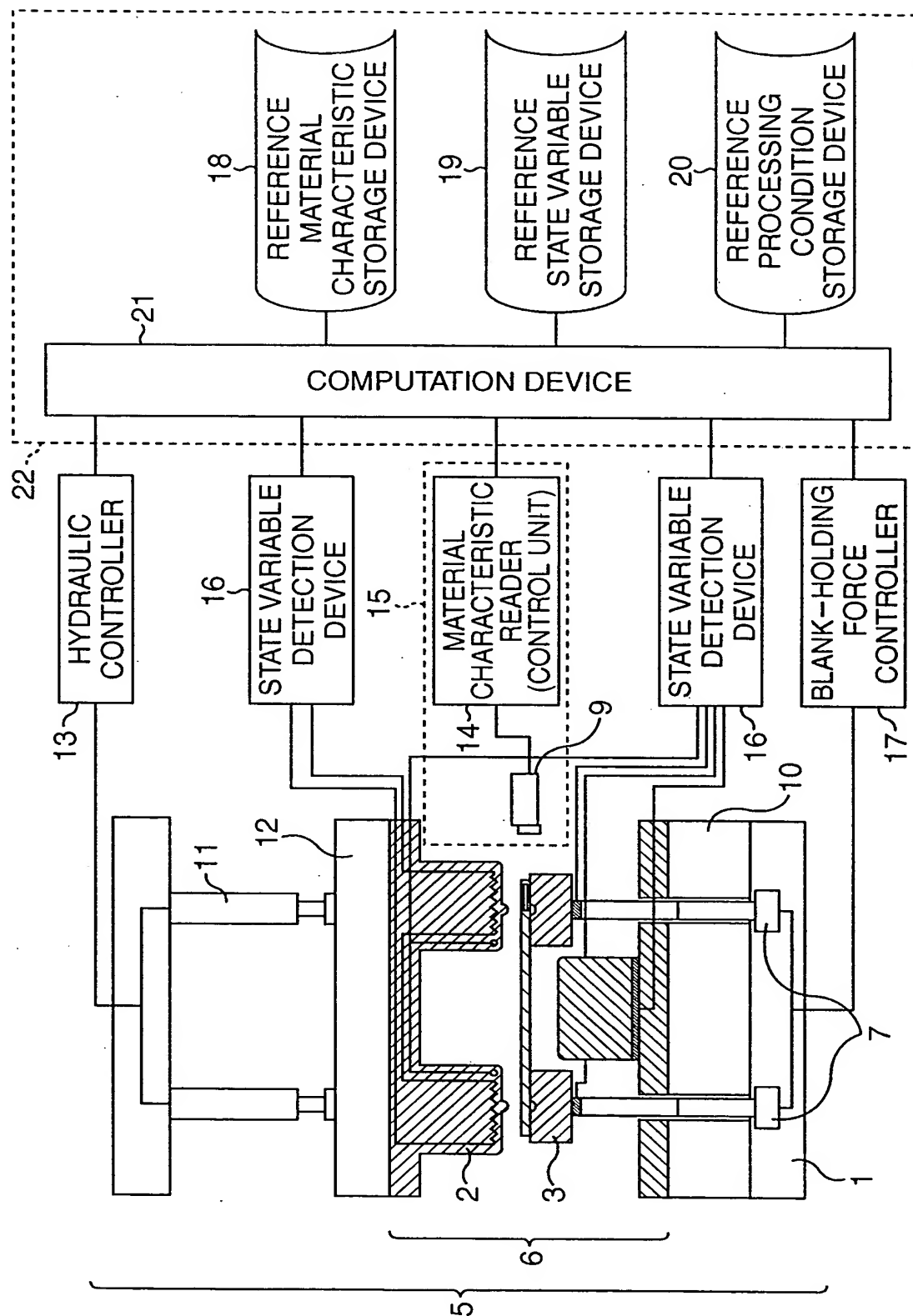


FIG. 2

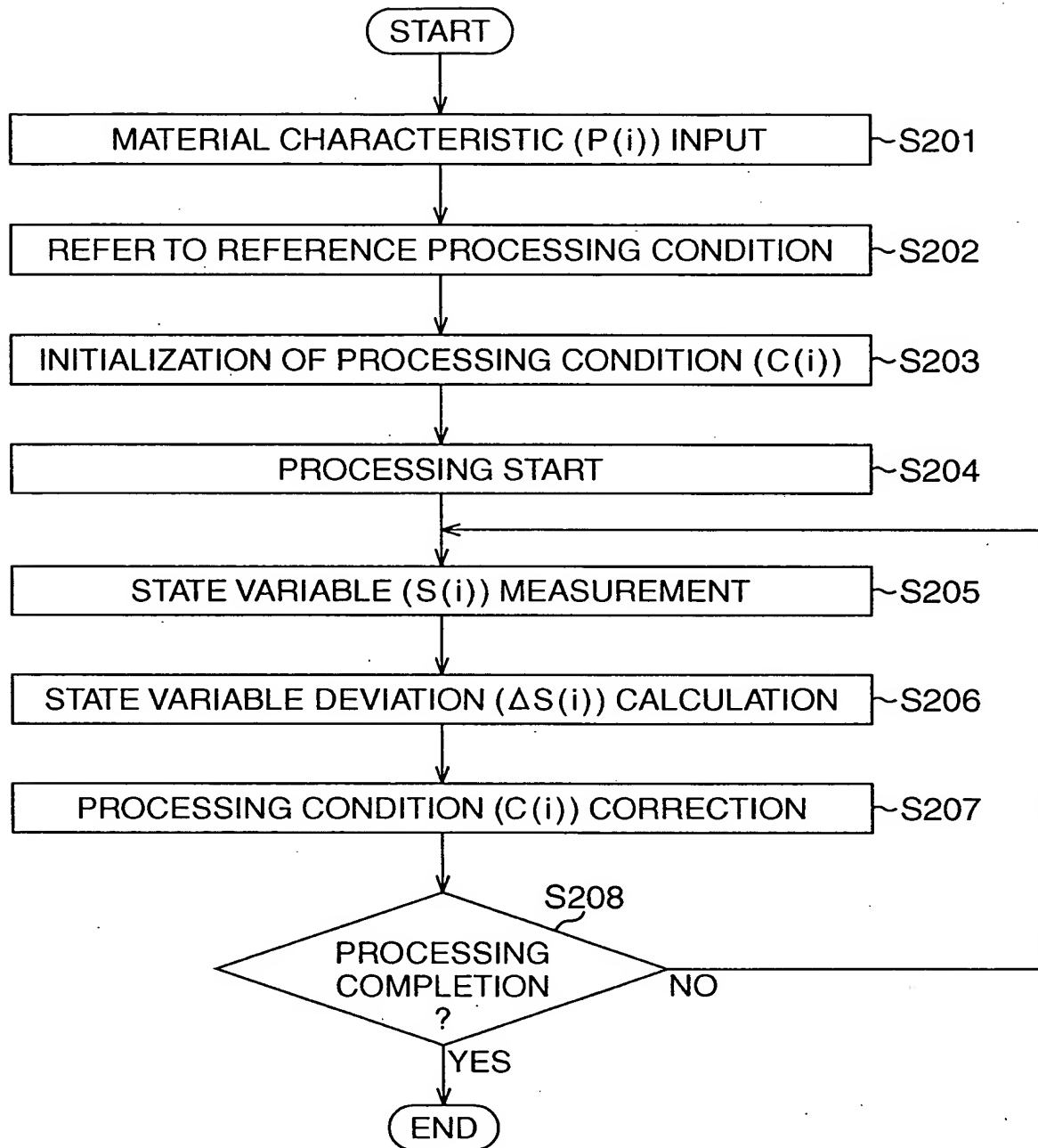


FIG. 3

[illegible]



FIG. 5

	P(1) (SHEET THICKNESS /mm)	P(2) (YIELD STRENGTH /MPa)	P(3) (TENSILE STRENGTH /MPa)	P(4) (TOTAL ELONGATION /%)	P(5) (HARDNESS /Hv)
COIL TYPICAL MECHANICAL PROPERTIES	1.175~ 1.225	145	285	43	145
REFERENCE VALUE	1.200	140	280	42	140

FIG. 6

STANDARD PROCESSING CONDITION	VALUE
C0 (1) (FORMING SPEED)	50mm/sec.
C0 (2) (BLANK-HOLDING FORCE)	50kN

FIG. 7

	P(1) (SHEET THICKNESS)	P(2) (YIELD STRENGTH)	P(3) (TENSILE STRENGTH)	P(4) (TOTAL ELONGATION)	P(5) (HARDNESS)
C0 (1) (FORMING SPEED)	0.2	0.2	0.3	0.4	0.2
C0 (2) (BLANK- HOLDING FORCE)	0.4	0.4	0.6	0.8	0.4

FIG. 8

	S(1) PUNCH REACTION 10mm	S(2) PUNCH REACTION 20mm	S(3) PUNCH REACTION 30mm	S(4) METAL MOLD TEMPERATURE (AT FORMING START)
REFERENCE VALUE	20kN	40kN	65kN	30°C

FIG. 9

	S(1) PUNCH REACTION 10mm	S(2) PUNCH REACTION 20mm	S(3) PUNCH REACTION 30mm	S(4) METAL MOLD TEMPERATURE (AT FORMING START)
C(1) (FORMING SPEED)	-1.0	-1.0	-1.0	-0.5
C(2) (BLANK-HOLDING FORCE)	-1.0	-1.0	-1.0	-0.5

FIG. 10

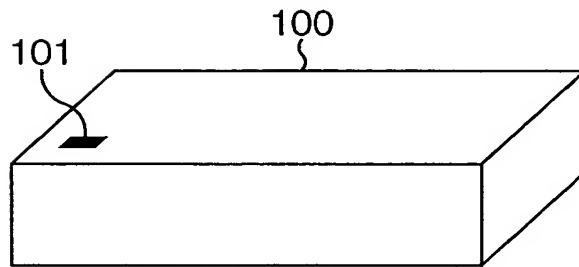


FIG. 11

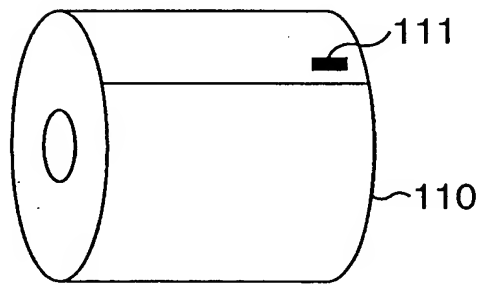




FIG. 12

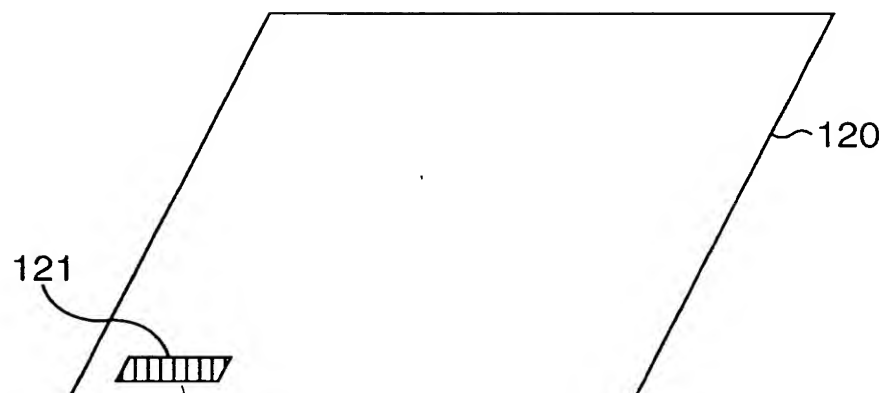


FIG. 13

